

Date: Monday, 02/03/2009 9:05:05 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASSEMBLY
Job Number : 46141	
Estimate Number : 10771	
P.O. Number :	Part Number : D3462042
This Issue : 02/03/2009 S.O. No. :	Drawing Number : D3462 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : C
Previous Run : 45060	Material :
Written By :	Due Date : 16/03/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JUD 09.03.02</u>	
Comment : EST REV. A 05.11.18 NEW ISSUE EC esr rev B 08.07.15 ecn 1049 EC verified by: DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34621	BRACKET ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~4~~ 6.0000 Each(s)

Base Flat Pattern

Pick:

Qty	Part Number	Description	Batch
1	D3462-1	Base Flat Pattern	B46266x6

EL 9-3-17

2.0	D34623	Lug
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~4~~ 6.0000 Each(s)

Flange

Pick:

Qty	Part Number	Description	Batch
1	D3462-3	flange	4XB45184 2X46267

EL 9-3-17

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3462

EL 9-3-17

4.0	QC9	VISUAL WELDING INSPECTION
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**Comment:** VISUAL WELDING INSPECTION

P/L 09.03.19

(x6)

5.0	QC5	INSPECT WORK TO CURRENT STEP
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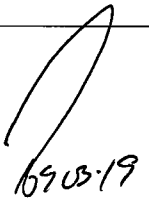
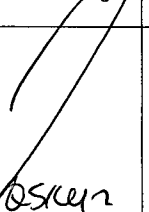

**Comment:** INSPECT WORK TO CURRENT STEP

09.03.19 (5)

PTU

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3462-042 PAR # N/A Fault Category: Prod / Mfg. Lg. NCR: (Yes) No DQA: D Date: 09/03/30
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: D Date: 09/03/30

NCR: <u>46141</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-03-19	3.0	1 part scrap. Part is 2° under from dwg. R.C. sh. - fterd to much during welding * process *		Scrap & no replace both angles are slightly off: Jig is good.	SAP 09-03-19			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 46141

Part Number: D3462042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



MA 110939



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME: 2:00pm

OVEN TEMPERATURE: 400°F

FINISH TIME: 2:30am

9/1 09-03-19 (5)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-03-20 (5)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 480

9/3/20

50

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/24

Job Completion



MF 09-03-23

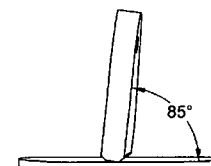
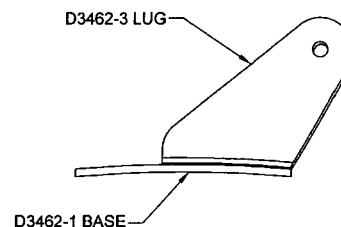
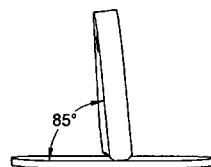
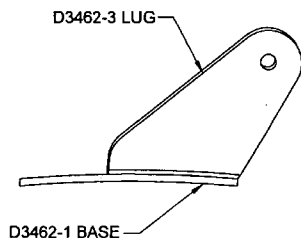
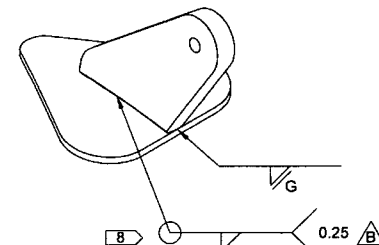
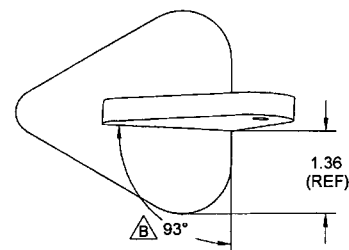
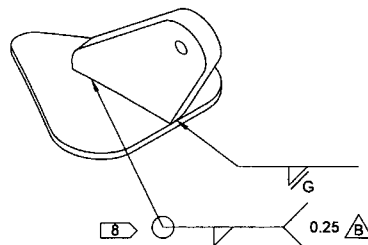
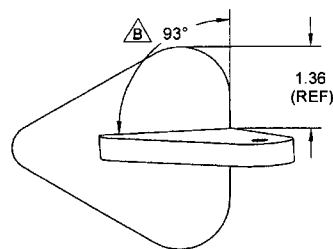
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3462-041 BRACKET ASSEMBLY

D3462-042 BRACKET ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3462-041	BRACKET ASSEMBLY
	X	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

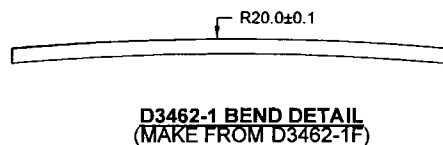
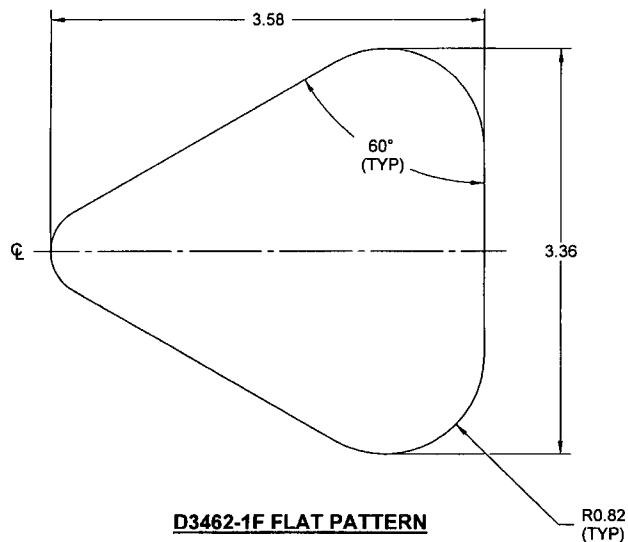
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.75 lbs (TYP)
- 8) WELDING: PER DART QSI 004

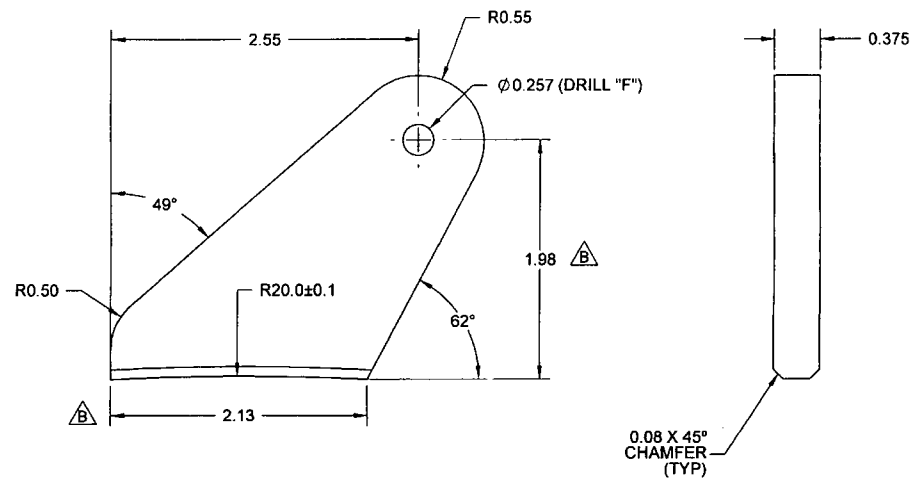
RELEASED
06/07/07 1:20

C	SHOW VIEWS OF D3462-041 & D3462-042, UPDATE DWG REASON: PRODUCTION FACILITY	DC	07.10.24
B	REVISE DIMENSIONS	RF	05.12.05
A	NEW ISSUE	RF	05.09.20
REV.	DESCRIPTION	BY	DATE
DESIGN	JP		
DRAWN	JP, DC		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	07.10.24		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3462 TITLE BRACKET ASSEMBLY COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			
		REV. C	SHEET 1 OF 2
		SCALE	1:2

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NO. *1017*
WORK ORDER



- NOTES:
- 1) MATERIAL: AISI 304 SS SHEET, 0.125 THICK
PER MIL-S-5019 (ANNEALED), 2B FINISH
(REF. DART SPEC. M304S11GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.28 lbs



- NOTES:
- 1) MATERIAL: AISI 304 SS BAR
(REF. DART SPEC M304B0.375X03.000)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.47 lbs

RELEASED
8-07-01

DESIGN	7	DART AEROSPACE LTD	
DRAWN	MD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MD	DRAWING NO.	REV. C
MFG. APPR.	MD	D3462	SHEET 2 OF 2
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DE APPR.	MD	BRACKET ASSEMBLY	
DATE	07.10.24	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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